

Work Order ID 50928

July 27, 2009 8:45:30 AM

Page 1

Item ID: D3558-9

Revision ID: B

Item Name: Gasket

Start Date: 07/27/2009 Start Qty: 12.00

Required Date: 07/31/2009 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: *mf*

Date: *09-07-27* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3558

Rev B

15

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3558 1 Dwg Rev: *B* 11 Prog Rev: *B* 12-
Deburr if necessary

HB 9-7-29

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 9-7-29

(15)

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 80212130

(45) f

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50928

July 27, 2009 8:45:30 AM



Page 2

Item ID: D3558-9

Accept



Setup Start



Revision ID: B

Item Name: Gasket

Stop



Start Date: 07/27/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 07/31/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

FINISHING

0.00

09/1/30 (15)

Packaging

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/07/31

30-07-09

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NOTE: Date & initial all entries

Picklist Print

July 27, 2009 8:45:29 AM

Page 1

Work Order ID: 50928

Parent Item: D3558-9RevB

Parent Item Name: Gasket

Comments:

Start Date: 07/27/2009

Required Date: 07/31/2009

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	377.1526	5.5579			
NEOPRENE SHEET 0.063												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	377.1526322	
111469	71.1	
111853	306.052632	

4431 per unit

6.9465

111853

18 9-7-09

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DART AEROSPACE LTD		Work Order: 50924
Description: Gasket		Part Number: D3558-9
Inspection Dwg: D3558	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.190	✓			
0.30	+/-0.030	.303	✗			
0.30	+/-0.030	.302	✗			
0.38	+/-0.030	.381	✗			
2.06	+/-0.030	2.073	✗			
2.73	+/-0.030	2.735	✗			
2.90	+/-0.030	2.90	✗			
5.80	+/-0.030	5.86	✗			
11.60	+/-0.030	11.66	✗			
17.40	+/-0.030	17.40	✗			

Measured by: LB	Audited by: S	Prototype Approval:	N/A
Date: 9-7-29	Date: 09/07/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	DD

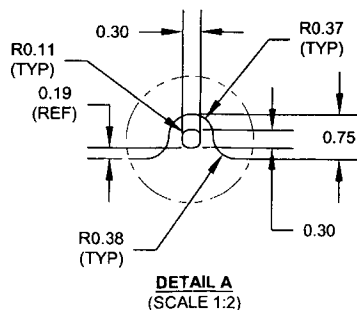
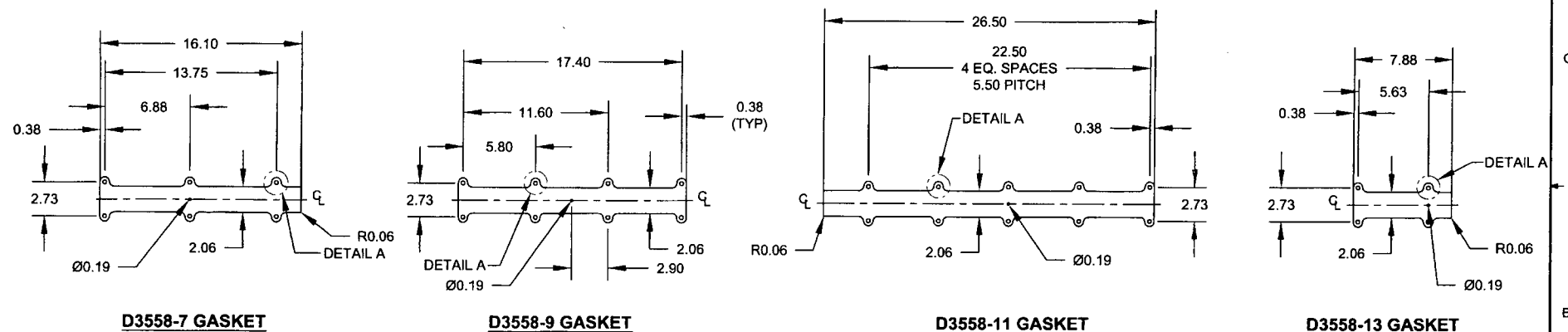
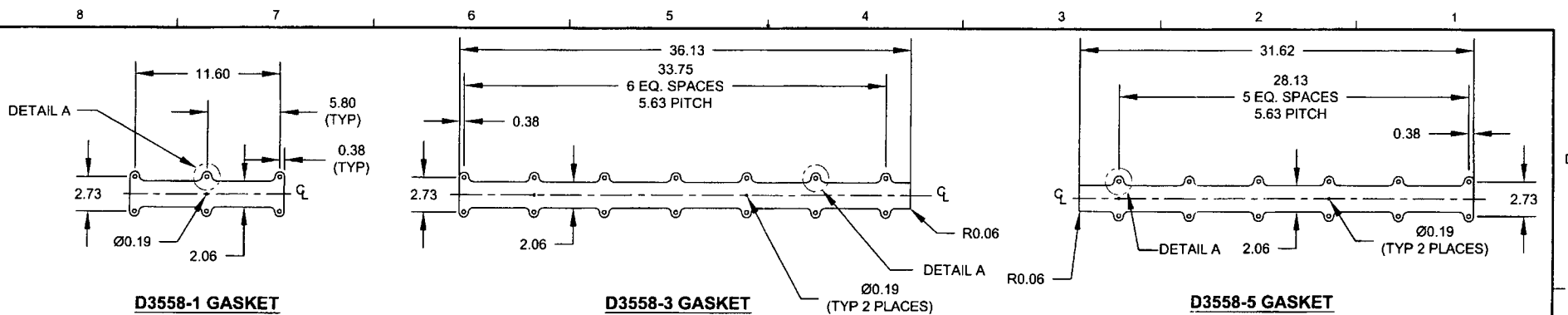
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NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF. DART SPEC. M-NEW60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3558-1 - 0.09 lbs, D3558-3 - 0.26 lbs, D3558-5 - 0.23 lbs, D3558-7 - 0.12 lbs, D3558-9 - 0.13 lbs, D3558-11 - 0.19 lbs, D3558-13 - 0.06 lbs

#30928
mf
09-07-27

RELEASED
07-11-16

B	ADD -9/11/13 UPDATE DRAWING FORMAT	PH	07.04.20
A	NEW ISSUE	PH	06.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	PAH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PAH		
CHECKED	PAH	DRAWING NO.	REV. B
MFG. APPR.	PAH	D3558	SHEET 1 OF 1
APPROVED	PAH	TITLE	SCALE
DE APPR.	PAH	GASKET	1:8
DATE	07.04.20	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

Dart Aerospace Ltd

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